

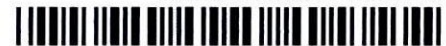


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9813

Job Sheet 169361



Part No: 646.9813

Job Qty: 12 ea

Part Name: Lower Deflector Low



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/8/17

Job Tracking No:

Due Date: 12/22/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 6 IPP REV: A NEW ISSUE 12/09/10 JFS VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		12/21/17	0.00	0.00	Start Up Machining-1		<i>SM</i> 17/12/15
100	Bandsaw	12 pcs		12/21/17	0.00	0.01	Bandsaw1		<i>SM</i> 17/12/15
110	CNC Vertical Machining	12 pcs		12/22/17	0.16	6.41	HAAS1-1		<i>SBL / MIP</i> 17/12/23
120	QC	12 pcs		12/22/17	0.00	0.00	QC2 Machining-1		<i>SBL / MIP</i> 17/12/23
130	QC	12 pcs		12/22/17	0.00	0.00	QC8 Machining-1		<i>SM</i> 17-12-27
140	Outsource	12 pcs		12/22/17			ATG001-VC		<i>SM</i>
150	Packaging	12 pcs		12/22/17	0.00	0.00	Packaging2		<i>DAS</i>
151	QC	12 pcs		12/22/17	0.00	0.00	QC5		<i>38</i>
180	Packaging	12 pcs		12/22/17	0.00	0.00	Packaging3-1	<i>CK015</i>	<i>AT</i> 18/04/24
190	QC21-SA	12 Ea		12/22/17	0.00	0.00	QC21		<i>21</i>

Part Op 100 - Cut Blank at 17.000" *make two*

Descriptions: 110 - 1-Machine per folio FB131

140 - Issue P/O to ATG:

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

HARD ANODIZE Block / Prime

as per dwg 646.9800

Rev A

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6S0.375X5.000	9	20	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Deflector, Low	0.130Inches ± 0.020	0.150 0.110		
2	Lower Deflector, Low	45.0Angle ± 0.5	45.5 44.5		
3	Lower Deflector, Low	0.040Inches ± 0.020	0.060 0.020		
4	Lower Deflector, Low	45.0Angle ± 0.5	45.5 44.5		
5	Lower Deflector, Low	2.110Inches ± 0.002	2.112 2.108		
6	Lower Deflector, Low	4.220Inches ± 0.002	4.222 4.218		
7	Lower Deflector, Low	0.177Inches	0.182		

5017359 X2 5022532
M138513X4 5022533

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification

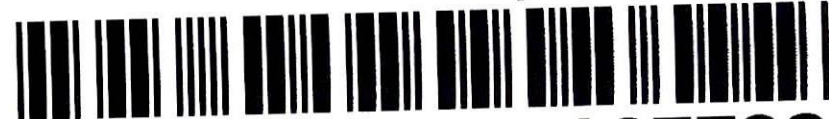
Job No: 169361
Mfg Date: 12/14/17

Start up Operation

646.9813

Change No: _____
Operation: _____
Revision: _____
PART NO: _____

Lower Deflector Low



S022537



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CANADA
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www.dartaerospace.com

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Force ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Con ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Rip ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in T ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : ☐

			+ 0.005 - 0.001	0.176
8	Lower Deflector, Low	0.340Inches	+ 0.000 - 0.005	0.340 0.335
9	Lower Deflector, Low	0.700Inches	± 0.020	0.720 0.680
10	Lower Deflector, Low	0.375Inches	± 0.010	0.385 0.365
11	Lower Deflector, Low	0.310Inches	± 0.010	0.320 0.300
12	Lower Deflector, Low	3.020Inches	± 0.020	3.040 3.000
13	Lower Deflector, Low	5.590Inches	± 0.020	5.610 5.570
14	Lower Deflector, Low	6.330Inches	± 0.020	6.350 6.310
15	Lower Deflector, Low	0.188Inches	+ 0.005 - 0.001	0.193 0.187

Plex 12/14/17 9:28 AM dart.poulin.mario

DART
AEROSPACE
S022537

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CANADA
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www.dartaerospace.com



Lower Deflector Low

PART NO: 646.9813
Original Serial #: S022537
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/14/17
Job No: 169361

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



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Tel (613) 632-5200

PURCHASE ORDER

PO038727

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18	169361	646.9813	Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C Lower Deflector Low Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.9800 Rev. A	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$11.85/pcs	\$142.20
19	169288	646.9910	Struts Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	1/30/17	25 pcs	0 pcs	25 pcs	\$14.10/pcs	\$352.50
20	166819	D4838-1	Upper Cutter Body, LH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-1 Rev. A	Firmed	1/30/17	10 pcs	0 pcs	10 pcs	\$10.95/pcs	\$109.50
21	166821	D4838-2	Upper Cutter Body, RH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed	1/30/17	1 pcs	0 pcs	1 pcs	\$10.95/pcs	\$10.95
22	166822	D4838-2	Upper Cutter Body, RH Issue P/O: _____ ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed	1/30/17	17 pcs	0 pcs	17 pcs	\$10.95/pcs	\$186.15
23	169560	SWA6A-800A	Connector Bushing -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	1/30/17	6 pcs	0 pcs	6 pcs	\$3.10/pcs	\$18.60
24	169654	SWA6A-700	Wire Clamp -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	1/30/17	12 pcs	0 pcs	12 pcs	\$7.45/pcs	\$89.40
25	169600	RBT18538-1	Left Seat Brace -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is	Firmed	1/30/17	2 pcs	0 pcs	2 pcs	\$14.58/pcs	\$29.16



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914459

Date: 22-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: 646.9813 Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22308	Rev: A	PO: PO038727 Line: 18
4 ea	Part: 647.1511 Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22296	Rev: D	PO: PO038727 Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>23/1/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. JAN 23 2018 Made in Canada.			